

Work Order ID 73278

Tuesday, August 30, 2011 12:01:11 PM

Page 1

Item ID: D3340-19

Revision ID:

Item Name: Center Skidtube Protector

Start Date: 8/29/2011 Start Qty: 4.00

Required Date: 9/9/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: *W*

Date:

QC:

Date:

Accept

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3340

Rev B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg.

1010 .040

Prog. rev: *B*

dwg rev: *B*

B11-9-20

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Ensure material release note is attached

B11-9-20

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/30/21

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73278

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Item ID: D3340-19

Accept

Setup Start

Revision ID:

Stop

Item Name: Center Skidtube Protector

Start Date: 8/29/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Deburr if necessary! Form on brake as per Dwg D3340 using Jigs DT and DT

8/11/09/22

(4)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/09/22

(4)

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

12:45

7:15

320°F

4X of m-f 11/09/22

M 117338

W/O:		WORK ORDER CHANGES					
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Work Order ID 73278

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Item ID: D3340-19

Accept



Setup Start



Revision ID:

Item Name: Center Skidtube Protector

Stop



Start Date: 8/29/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4

BR 11-9-22

170

Identify as per dwg & Stock Location *SP 500*

0.00



Packaging

Memo

0.00

Packaging

[Signature]



SP 11-09-22

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/27 *[Signature]*

MF 11-09-26

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, August 30, 2011 12:01:09 PM

Page 1

Work Order ID: 73278

Parent Item: D3340-19

Parent Item Name: Center Skidtube Protector




Start Date: 8/29/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A 05.11.10 Preliminary issue AP/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3340-19F  Wearplate		Purchased	No			100	Each	0.0000	1	4	4	8/11-9-20	



1010 .040

M 116 791

(4)

M1010320 GA

W/O:		WORK ORDER CHANGES					
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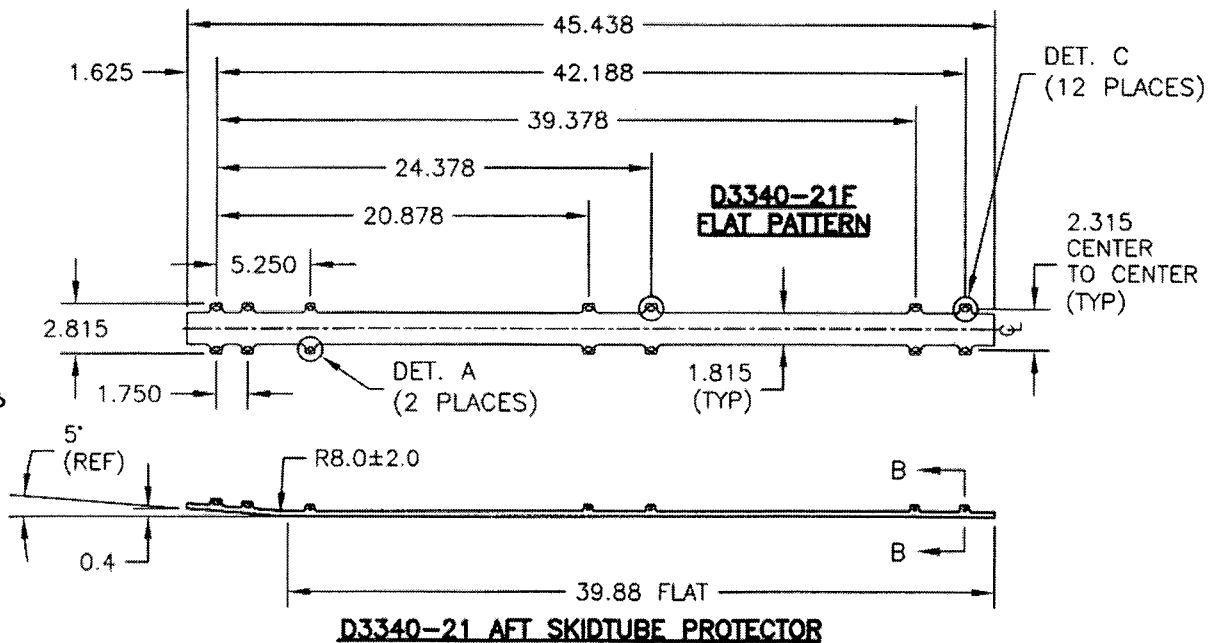
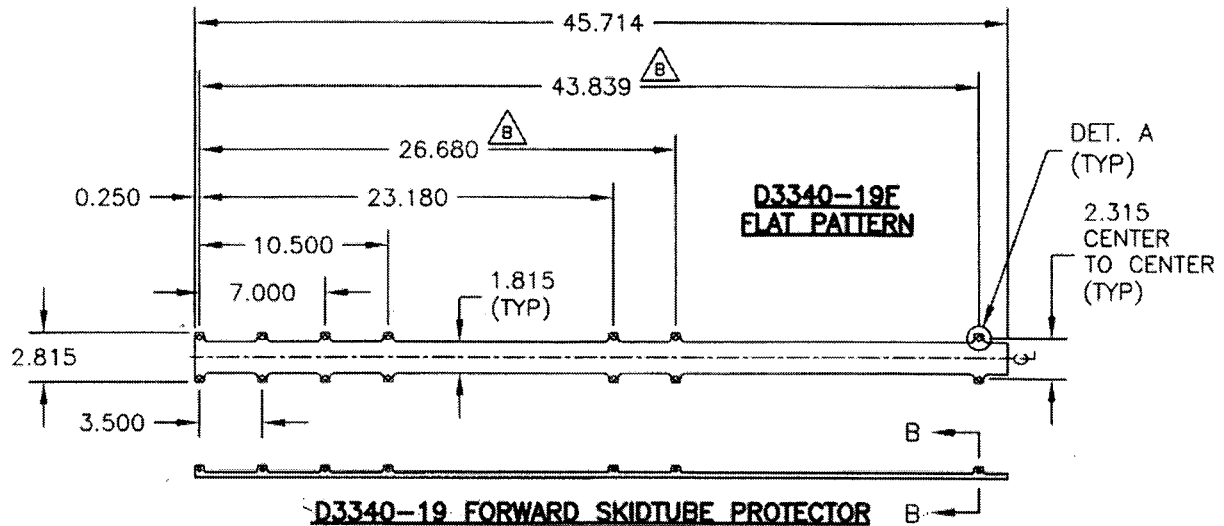
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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 8 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

RELEASED
05.11.28

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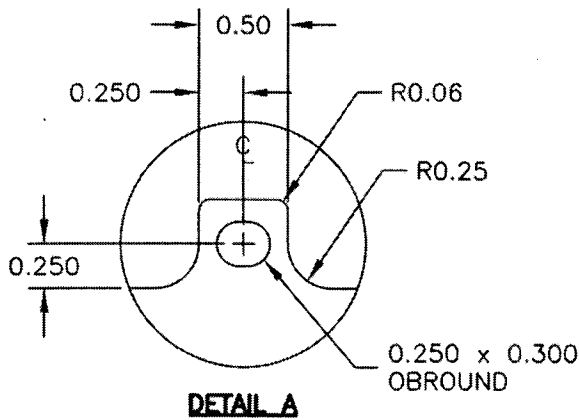
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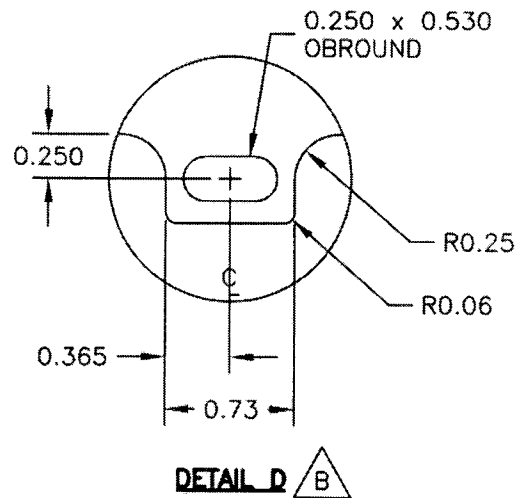
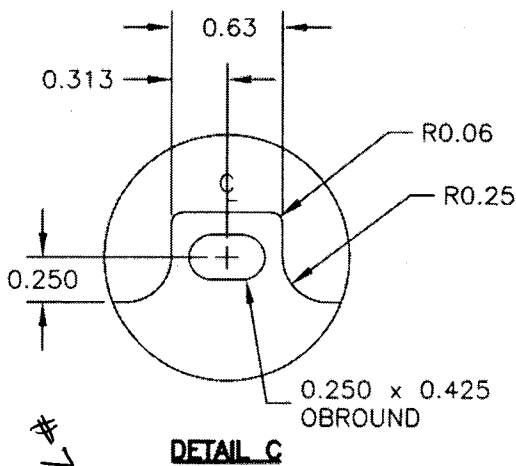
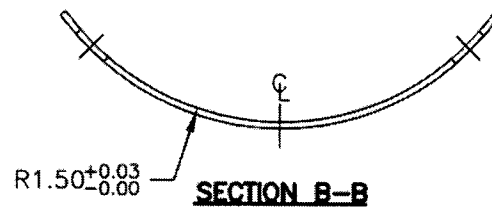
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3340	REV. 8 SHEET 11 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1



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05-11-28



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